

Work Order ID 70609

Monday, June 13, 2011 11:49:17 AM



Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9494

A

IIN-D412-706

A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

Sub 102 *AG for BG 11-8-2*

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

JB *11/07/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70609

Monday, June 13, 2011 11:49:17 AM



Page 2

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

846962



130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD412-706-011

Location: _____
PPP Rev: E

0.00

0.00

6/18/02 (1)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/12

MF 11-09-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:49:23 AM

Page 1

Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM
 IPP Rev:F 08-05-14 revise comment in seq.17/24 DD verified
 by:EC IPP rev G
 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23
 as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per
 chg003 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A Bolt		Purchased	No			110	Each	1,122.000	4	4	✓		JB
<div> <div>Location</div> <div>ST350</div> <div>115371</div> <div>117423</div> </div> <div> <div>Loc Qty</div> <div>1122</div> <div>322</div> <div>800</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
AN814-6D Plug		Purchased	No			110	Each	9.0000	1	1	✓		JB
<div> <div>Location</div> <div>ST329</div> <div>117946</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
AN815-6D Union-M-Flare		Purchased	No			110	Each	3.0000	2	2	✓		JB
<div> <div>Location</div> <div>ST329</div> <div>117514</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
										117423			
										117946			
										118368 x 1		1407/27	
										117514 x 1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN815-8D

Purchased

No

110

Each

8.0000

1

1

Union-M-Flare

Location

Loc Qty

Loc Code

ST329

8

114544

8

110

Each

11.0000

1

1

AN832-6D

Purchased

No

UNION

Location

Loc Qty

Loc Code

ST333

11

117771

1

117909

10

110

Each

10.0000

2

2

AN833-6D

Purchased

No

Elbow, Bulkhead-M-Flare

Location

Loc Qty

Loc Code

ST333

10

118006

10

110

Each

9.0000

1

1

AN833-8D

Purchased

No

ELBOW

Location

Loc Qty

Loc Code

ST333

9

114544

9

110

Each

10.0000

4

4

AN924-6D

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST335

10

117909

10

Monday, June 13, 2011 11:49:23 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Page 3

Monday, June 13, 2011 11:49:23 AM

Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN924-8D	Purchased	No	110	Each	7.0000	1	1	✓	
NUT									

Location Loc Qty Loc Code

MEZZ

7

114544

7

AN938-6D	Purchased	No	110	Each	9.0000	1	1	✓	
Tee									

Location Loc Qty Loc Code

ST336

9

101925

9

AN960JD10	Purchased	No	110	Each	0.0000	8	8	✓	
Washer									

AN960JD10L	Purchased	No	110	Each	0.0000	4	4	✓	
Washer									

AN960JD916	Purchased	No	110	Each	0.0000	2	2	✓	
WASHER									

D2001-4	Manufactured	No	110	Each	2.0000	1	1	✓	
Valve Assembly (1/4")									

Location Loc Qty Loc Code

ST002

2

68025

2

D3262-043	Manufactured	No	110	Each	0.0000	1	1	✓	
Canister Assembly									

Monday, June 13, 2011 11:49:24 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

Monday, June 13, 2011 11:49:24 AM

Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3264-1 Manufactured No 110 Each 0.0000



Bracket

D3297-1-0098 Manufactured No 110 Each 4.0000



HOSE ASS'Y



2 2 B70614 SF 11/8/25



1 1 JB

Location

Loc Qty

Loc Code

ST194

4

70218

4

D3297-3-0085 Manufactured No 110 Each 4.0000



HOSE ASS'Y



70218

1

JB

Location

Loc Qty

Loc Code

ST194

4

70219

4

D3297-3-0210 Manufactured No 110 Each 4.0000



HOSE ASS'Y



70219

1

JB

Location

Loc Qty

Loc Code

ST194

4

70220

4

D3298-005 Manufactured No 110 Each 8.0000



Tube Assembly



70220

1

JB 11/07/27

Location

Loc Qty

Loc Code

ST195

8

47505

3

48509

1

55527

4

55527

Monday, June 13, 2011 11:49:24 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Monday, June 13, 2011 11:49:24 AM

Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3298-007

Manufactured No

110 Each

4.0000

1

1

✓

Tube Assembly

Location

Loc Qty

Loc Code

ST195

4

58969

4

110 Each

10.0000

1

1

✓

D3299-3

Manufactured No

Fitting

Location

Loc Qty

Loc Code

ST046

10

42171

4

55530

6

110 Each

11.0000

1

1

✓

D3299-5

Manufactured No

Fitting

Location

Loc Qty

Loc Code

ST047

11

43657

5

55531

6

110 Each

5.0000

1

1

✓

D3299-7

Manufactured No

Fitting

Location

Loc Qty

Loc Code

ST047

5

57411

5

57411

Monday, June 13, 2011 11:49:24 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3301-1
Placard

Manufactured No

110 Each

7.0000

1

1

Location

Loc Qty

Loc Code

ST047

7

56685

7

110 Each

5.0000

1

1

D3301-3
Placard

Manufactured No

Location

Loc Qty

Loc Code

ST047

5

60250

5

110 Each

0.0000

1

1

D3302-1
Doubler

Manufactured No

D3302-3
Doubler

Manufactured No

110 Each

0.0000

1

1

D3329-1
Bushing

Manufactured No

110 Each

10.0000

2

2

Location

Loc Qty

Loc Code

ST048

10

70257

10

110 Each

5.0000

1

1

D4054-001
Tube Assembly

Manufactured No

Location

Loc Qty

Loc Code

ST193

5

58155

5

58155

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:49:25 AM

Work Order ID: 70609

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4054-003

Manufactured No

110 Each

5.0000



Tube Assembly



1 1
JB LU

Location

Loc Qty

Loc Code

ST193

5

58156

5

58156

D4054-009

Manufactured No

110 Each

1.0000



Tube Assembly



1 1
73078 LU

Location

Loc Qty

Loc Code

ST193

1

70258

1

~~70258~~

MS21042L3

Purchased No

110 Each

2,280.000



Nut



4 4
JB LU

Location

Loc Qty

Loc Code

ST300

2280

116391

9

116549

571

117441

800

117601

400

117885

500

117441

MS21919-WDG9

Purchased No

110 Each

36.0000



Clamp



2 2
118234 JB 11/07/27 LU

Location

Loc Qty

Loc Code

ST309

36

116702

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS21920-42

Purchased

No

110

Each

2.0000

2

2



CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

2

117407

2

110

Each

20.0000

8

8

MS29512-06

Purchased

No



O-RING

Location

Loc Qty

Loc Code

ST294

20

117946

20

110

Each

21.0000

2

2

MS29512-08

Purchased

No



O-RING

Location

Loc Qty

Loc Code

ST294

21

113706

1

117962

20

110

Each

12.0000

1

1

MS35489-11

Purchased

No



GROMMET

Location

Loc Qty

Loc Code

ST296

12

109166

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54
REF FAA STC: SR02055NY
REF. EASA STC: EASA.IM.R.S.01180

DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS

QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING

Continue on next sheet

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 11.06.06
CERT. NO.: SH04-54
ISSUE NO.: 1

B	SHEET 2: D412-706-011 KIT: QTY(7) MS29512-06 WAS QTY(8), QTY(3) MS29512-08 WAS QTY(2), MS35489-16 WAS MS35489-11; DSI 9494-011 KIT P/L: ADDED AN814-8D PLUG AND MS35489-16 GROMMET, QTY(3) MS29512-08 O-RING WAS QTY(2). SHEET 3: AN814-8D PLUG WAS AN814-6D PLUG AND MS29512-08 WAS MS29512-06. REASON: NCR11-641.		MB	11.06.03
A	NEW ISSUE		RF	10.01.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	R			
CHECKED	UP	DRAWING NO.	REV. B	
MFG. APPR.	N/A	DSI 9494	SHEET 1 OF 3	
APPROVED	SH	TITLE	SCALE	
DE APPR.	SH	212/412 CANISTER UPGRADE KIT	NTS	
DATE	11.06.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

REFERENCE ONLY

Continue from previous sheet

B	4	AN3-5A	BOLT
	1	AN814-8D	PLUG
	2	AN815-6D	UNION
	1	AN815-8D	UNION (WAS AN815-6D)
	1	AN832-6D	UNION
	1	AN833-6D	ELBOW
	1	AN833-8D	ELBOW (WAS AN833-6D)
	4	AN924-6D	NUT
	1	AN924-8D	NUT (WAS AN924-6D)
	1	AN938-6D	TEE
	4	AN960JD10L	WASHER (OR NAS1149D0332J)
	8	AN960JD10	WASHER (OR NAS1149D0363J)
	2	AN960JD916	WASHER
	4	MS21042L3	NUT
	2	MS21919WDG9	CLAMP
	2	MS21920-42	CLAMP
	7	MS29512-06	O-RING (WAS MS28778-6)
B	3	MS29512-08	O-RING (WAS MS28778-8)
	1	MS35489-16	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.





	QTY -011	PART NUMBER	DESCRIPTION
	X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
	1	D3262-043	CANISTER ASSEMBLY
	1	D4054-001	TUBE ASSEMBLY
	1	D4054-003	TUBE ASSEMBLY
	1	D4054-009	TUBE ASSEMBLY
	1	D3299-7	FITTING
B	1	AN814-8D	PLUG
	1	AN815-8D	UNION
	1	AN833-8D	ELBOW
	1	AN924-8D	NUT
B	3	MS29512-08	O-RING
	1	MS35489-16	GROMMET

WEIGHT AND BALANCE:
NO CHANGE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.06.06
CERT. NO.: SH04-54
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9494	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
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